

28

Date: Thursday, 7/3/2008 3:31:46 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOOR SUPPORT KIT		
Job Number	40225					
Estimate Number	12112					
P.O. Number	:		Part Number	D412698015		
This Issue	7/3/2008	S.O. No. :	Drawing Number	IIN D412-698 REV D		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type :	Drawing Revision	D		
Previous Run	38438		Material	:		
Written By	:		Due Date	7/10/2008	Qty:	10 Um: Each
Checked & Approved By	:					
Comment	Est Rev:C Removed Manufacturing 06-01-25 JLM Est Rev:D change to rev D ECN 1104 08-01-28 DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	DC	DOCUMENT CONTROL	JLD 08.7.08	
2.0	PACKAGING 1	PACKAGING RESOURCE #1		
3.0	D32001	Door Post Block		
4.0	D32003	Door Wedge		
5.0	D32011	Doubler	(12) B40254 8/7/10	

Comments and handwritten notes:

- Line 1: Comment: DOCUMENT CONTROL. Photocopy bluefile and create labels per PPP D412-698-015 CHG001. Handwritten note: 800/2/16
- Line 2: Comment: PACKAGING RESOURCE #1. Pick Packing Kit.
- Line 3: Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s). Pick: Packing Kit. Qty Part Number Description Batch 2 D3200-1 Door Post Block 40253
- Line 4: Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s). Pick: Packing Kit. Qty Part Number Description Batch 2 D3200-3 Door Wedge B38526
- Line 5: Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s). Pick: Packing Kit. Qty Part Number Description Batch 2 D3201-1 Doubler B36705 8X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 40225

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 D32013

Doubler

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-3 Angle B 36706

7.0 D32014

Doubler

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-4 Angle B 36707

8.0 AN960JD10L

Washer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD10L Washer M10 4885

9.0 MS21042L3

Nut

Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3) M10 7665

10.0 MS24693S277

Screw

Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS24693-S277 Screw M10 7737

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 40225

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



S 08/07/16 (eo)

Comment: INSPECT 100% KITS FOR COMPLETENESS

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(eo)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-015

Location: \_\_\_\_\_

PPP Rev: A

8/7/16

sd

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/17 (eo)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *400025*